

Work Order ID 113523

113523

Wednesday, February 19, 2014 3:19:49 PM

AOG ASD mem/2014/02/19 Page 1

Item ID: D350-591-113 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: HELI ACCESS STEP SHORT STEP HIGH SKID
 Start Date: 2/19/2014 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 2/24/2014 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ME Date: 14-2-19 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2310 | D | | | | | | | | |
| DSI 9525 | A | | | | | | | | |

100 0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-591-113

CHG005

DAS
31
9-89

14-02-21

(2)

ML5

14-02-21

110 0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut D2244 extrusion to 62.00" long as per Dwg D2310
 2-Drill extrusion as per Dwg D2310 using drill Jig DT8230
 3-Debur

2

d

H

14-02-19

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
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FAULT CATEGORY

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DQA: _____ Date: _____



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 Start Date: 2/19/2014 Start Qty: 2.00 ***2*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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|---|--|----------------------|---------|------------------------------|--------------|---------------|---------------|------------------|----------------|
| 210 *210* Powdercoat Powder Coating | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M128027</i> Memo START TIME: <i>8:35</i> OVEN TEMPERATURE: <i>220°</i> FINISH TIME: <i>9:05</i> | 0.00 0.00 | | | | <i>2</i> | <i>0</i> | <i>14-2-21</i> | <i>838</i> |
| 220 *220* HandFinish Hand Finishing | Wing Walk as per dwg QSI005 4.4 Batch <i>M128100.00</i> Memo | 0.00 | | | | <i>2</i> | <i>0</i> | <i>14-6-21</i> | |
| 230 *230* QC Quality Control | QC3- Inspect Part Finish Memo | 0.00 0.00 | | <i>SPD</i> <i>14/2/21</i> | | <i>2</i> | | | |

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| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|

Work Order ID 113523***113523***

Page 7

Wednesday, February 19, 2014 3:19:49 PM

Item ID: D350-591-113

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: HELI ACCESS STEP SHORT STEP HIGH SKID

Start Date: 2/19/2014 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 2/24/2014 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

QC21- Final Inspection - Work Order Release

0.00

270

QC

Memo

0.00

Quality Control

*14-02-21**14-02-21*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Page 1

Wednesday, February 19, 2014 3:19:48 PM

Work Order ID: 113523

113523

Parent Item: D350-591-113

D350-591-113

Parent Item Name: HELI ACCESS STEP SHORT STEP HIGH SKID

Start Date: 2/19/2014

Required Date: 2/24/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:H04.11.09ReformatKJ/JLM
ECN10-586 10.06.18 DD verf:EC

IPP Rev:E as per

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|--------------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2244-116 | | Manufactured | No | | | 110 | Each | 57.0000 | 1 | 2 | | | |
| *D2244-116* | | | | | | | | | | | | | |
| STEP EXTRUSION | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|------------|----------|
| WA003 | 56.9999632 | |
| 60307 | 9 | |
| 80803 | 24 | |
| 89954 | 24 | |

| | | | | | | | | | | | | | |
|----------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2275 | | Manufactured | No | | | 130 | Each | 57.0000 | 1 | 2 | | | |
| *D2275* | | | | | | | | | | | | | |
| Bushing | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 57 | |
| 107673 | 37 | |
| 108945 | 20 | |

| | | | | | | | | | | | | | |
|------------------------|--|--------------|----|--|--|-----|------|---------|---|---|--|--|--|
| D2582 | | Manufactured | No | | | 170 | Each | 14.0000 | 1 | 2 | | | |
| *D2582* | | | | | | | | | | | | | |
| Hi-Skid Step Leg Ass'Y | | | | | | | | | | | | | |

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA003 | 14 | |
| 106091 | 2 | |
| 111490 | 12 | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Wednesday, February 19, 2014 3:19:48 PM

Work Order ID: 113523

113523

Parent Item: D350-591-113

D350-591-113

Parent Item Name: HELI ACCESS STEP SHORT STEP HIGH SKID

Start Date: 2/19/2014

Required Date: 2/24/2014

Start Qty: 2.00

Required Qty: 2.00

D2673-34 Manufactured No 130 Each 33.0000 2 4

D2673-34

End Plate

**

14.02.20

Location

Loc Qty

Loc Code

WA003

33

109579

33

K591-113

DAS
31
9.09

Manufactured No

240 Each

0.0000

1

2

K591-113

Short Step Instln

**

113550

MS20600-AD4W3

Purchased No

170 Each

711.0000

16

32

MS20600-AD4W3

Cherry Rivets

**

14.02.20

Location

Loc Qty

Loc Code

ST311

342

122151

94

m127476

248

WA003

369

107939

369

32

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
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| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Handling/Pre <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
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| Transport <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

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|------------------------|-------------------------|--|------------------------|
| DESIGN KE | DRAWN BY PH | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D2310 | REV. D SHEET 1 OF 2 |
| DATE 05.11.14 | | TITLE HIGH SHORT STEP ASSEMBLY | SCALE NTS |
| A | 94.11.10 | NEW ISSUE | |
| B | 97.05.22 | END CAPS CHANGED | |
| C | 97.07.23 | ADDED BUSHING AND FACING INFO | |
| D | 05.11.14 | UPDATE FINISHING NOTE | |

D2310 HIGH SHORT STEP ASSEMBLY PARTS LIST

| Part No. | Description | QTY |
|--------------|--------------------------|-----|
| D2310 | High Short Step Assembly | X |
| D2244-62.0 | STEP EXTRUSION* | 1 |
| D2275 | BUSHING | 1 |
| D2582 | STEP LEG ASSEMBLY | 1 |
| D2673-34 | STEP END PLATE | 2 |
| MS20600AD4W3 | Rivets | 16 |

*cut per drawing

#113523

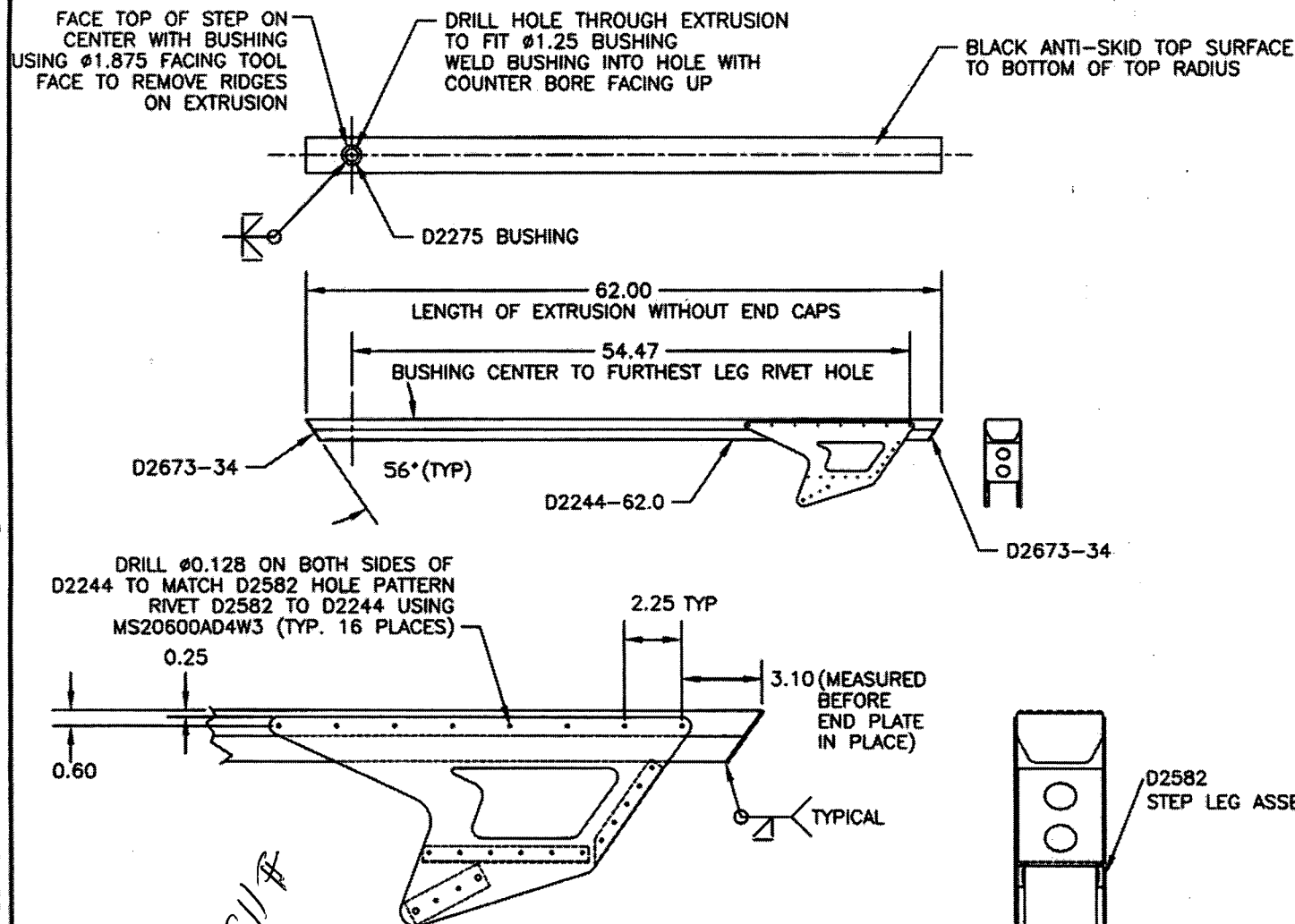
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| DATE 05.11.14 | TITLE HIGH SHORT STEP ASSEMBLY | SCALE NTS | |



STEP LEG DETAIL

D2310 HIGH SHORT STEP ASSEMBLY

- 1) MAKE FROM D2244 STEP EXTRUSION
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 REV. 3
REF TCCA STC: SH92-6
REF FAA STC: SH967NE

PURPOSE:

TO PROVIDE AN OPTIONAL CUSHION KIT TO BE INSTALLED ON THE D350-591-111A/-113/-115/-117A/-119 Heli-Access-Step™ (THE D2856-400-720 ABRASION STRIP IS REPLACED WITH THE D3595-200-300 CUSHION).

CHANGE:






FOR D350-591-111A/-113/-115 @ CHG 005 (OR LATER), D350-591-117A @ CHG 003 (OR LATER) AND D350-591-119 @ CHG 004 (OR LATER), THE PARTS LIST OF INSTALLATION INSTRUCTIONS D350-591 AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-591 IS AMENDED AS FOLLOWS:

| QTY -111A | QTY -113 | QTY -115 | QTY -117A | QTY -119 | Part Number | Description |
|--------------|-------------|-------------|--------------|-------------|---------------|---|
| X | | | | | D350-591-111A | Heli-Access-Step™, Long Step – High Skid |
| | X | | | | D350-591-113 | Heli-Access-Step™, Short Step – High Skid |
| | | X | | | D350-591-115 | Heli-Access-Step™, Short Step – Low Skid |
| | | | X | | D350-591-117A | Heli-Access-Step™, Pre-Flight Step |
| | | | | X | D350-591-119 | Heli-Access-Step™, Long Step – Low Skid |
| | 1 | | | | D2310 | STEP ASSEMBLY (HIGH-SHORT) |
| 1 | | | | | D2311 | STEP ASSEMBLY (HIGH-LONG) |
| | | 1 | | | D2354 | STEP ASSEMBLY (LOW-SHORT) |
| | | | | 1 | D2355 | STEP ASSEMBLY (LOW-LONG) |
| 4 | 2 | 2 | 2 | 2 | D2171 | CLAMP |
| 4 | 2 | 2 | 2 | 2 | D2182B035 | CUSHION |
| 8 | 4 | 4 | 4 | 4 | D2274 | RADIUS BLOCK |
| | | | 1 | | D2362-041 | SUPPORT BRACKET |
| 2 | 1 | | | 1 | D2362-3 | SUPPORT BRACKET |
| | | 1 | | | D2362-5 | SUPPORT BRACKET |
| 2 | 1 | 1 | 1 | 1 | D3595-200-300 | CUSHION (NEW) |
| 2 | 2 | 2 | | 2 | AN3-37A | BOLT |
| | | 4 | | | AN4-20A | BOLT (REPLACED, WAS AN4-16A) |
| 8 | 4 | | | 4 | AN4-21A | BOLT (REPLACED, WAS AN4-20A) |
| 1 | 1 | 1 | 4 | 1 | AN4-22A | BOLT |
| 4 | 4 | 4 | | 4 | NAS1149D0363J | WASHER (OR AN960JD10) |
| 10 | 6 | 2 | 4 | 6 | NAS1149D0463J | WASHER (OR AN960JD416) |
| | | 4 | | | NAS1149D0416J | WASHER (OR AN960JD416L) |
| 2 | 2 | 2 | | 2 | MS21042L3 | NUT |
| 9 | 5 | 5 | 4 | 5 | MS21042L4 | NUT |

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.06.08
CERT. NO.: SH92-6
ISSUE NO.: 11

| | | | |
|------------|---|---|--------------|
| A | NEW ISSUE. | JPH | 10.06.08 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN |  | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN |  | | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. | N/A | DSI 9525 | SHEET 1 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | STEP CUSHION CHANGE | NTS |
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113523

THE DSI-9525-XXX KITS THAT ARE AVAILABLE FROM DART TO UPGRADE THE D350-591-111A/-113/-115 KITS @ CHG 004 (OR EARLIER), THE D350-591-117A KIT @ CHG 002 (OR EARLIER) AND THE D350-591-119 KIT @ CHG 003 (OR EARLIER) ARE AS FOLLOWS:

| QTY -011 | QTY -013 | QTY -015 | QTY -017 | Part Number | Description |
|-------------|-------------|-------------|-------------|---------------|--|
| X | | | | DSI-9525-011 | STEP CUSHION KIT (FOR D350-591-111A) |
| | X | | | DSI-9525-013 | STEP CUSHION KIT (FOR D350-591-113/-119) |
| | | X | | DSI-9525-015 | STEP CUSHION KIT (FOR D350-591-115) |
| | | | X | DSI-9525-017 | STEP CUSHION KIT (FOR D350-591-117A) |
| 2 | 1 | 1 | 1 | D3595-200-300 | CUSHION |
| | | 4 | | AN4-20A | BOLT |
| 8 | 4 | | | AN4-21A | BOLT |
| | | | 4 | AN4-22A | BOLT |
| 8 | 4 | 4 | 4 | NAS1149D0463J | WASHER (OR AN960JD416) |
| 8 | 4 | 4 | 4 | MS21042L4 | NUT |

INSTRUCTIONS:

TO INSTALL THE D3595-200-300 CUSHION:

1. REMOVE THE STEP PER ICA-D350-591 SECTION 32.2
2. REMOVE THE D2856-400-720 ABRASION STRIP PER ICA-D350-591 SECTION 32.4
3. POSITION THE D3595-200-300 CUSHION AS INDICATED ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.
4. REINSTALL THE STEP PER ICA-D350-591 SECTION 32.1 AS APPLICABLE USING THE NEW HARDWARE PROVIDED AS SHOWN ON SHEET 3 OR 4 (AS APPLICABLE) OF THIS SERVICE INSTRUCTION.

WEIGHT AND BALANCE:

THERE IS A NEGLIGIBLE WEIGHT INCREASE WITH THIS MODIFICATION.

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
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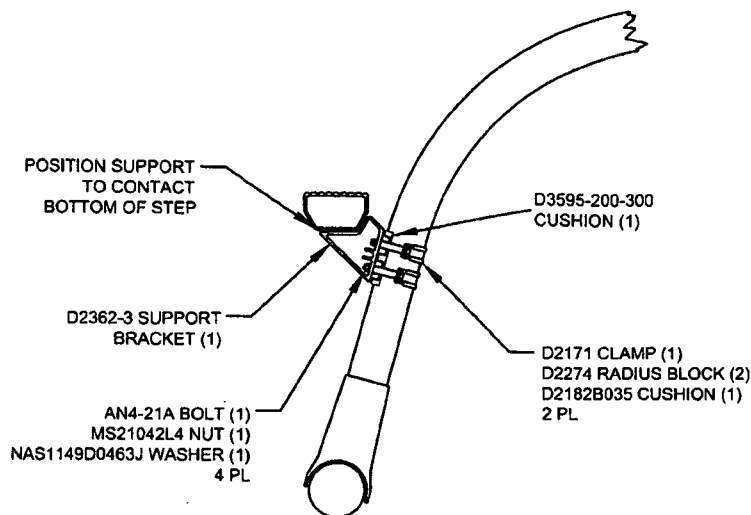
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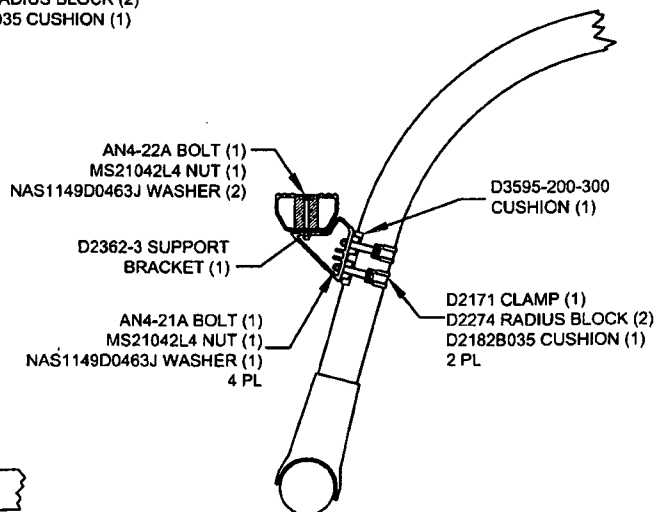
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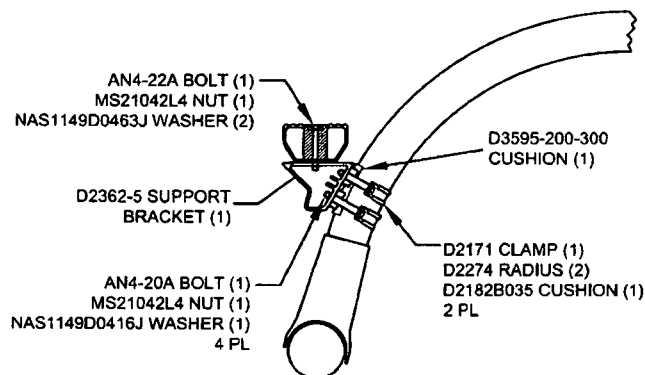
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SECTION C-C: CENTER SUPPORT
(D350-591-111A ONLY)
(NOT TO SCALE)



SECTION D-D: AFT ATTACHMENT
(D350-591-111A/-113/-119 ONLY)
(NOT TO SCALE)



SECTION E-E: AFT ATTACHMENT
(D350-591-115 ONLY)
(NOT TO SCALE)

FIGURE 32-9: Crosstube Attachment
REF ICA-D350-591

FIGURE 9: Crosstube Attachment
REF D350-591

#113523

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DAO # 01-O-01





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BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.06.08

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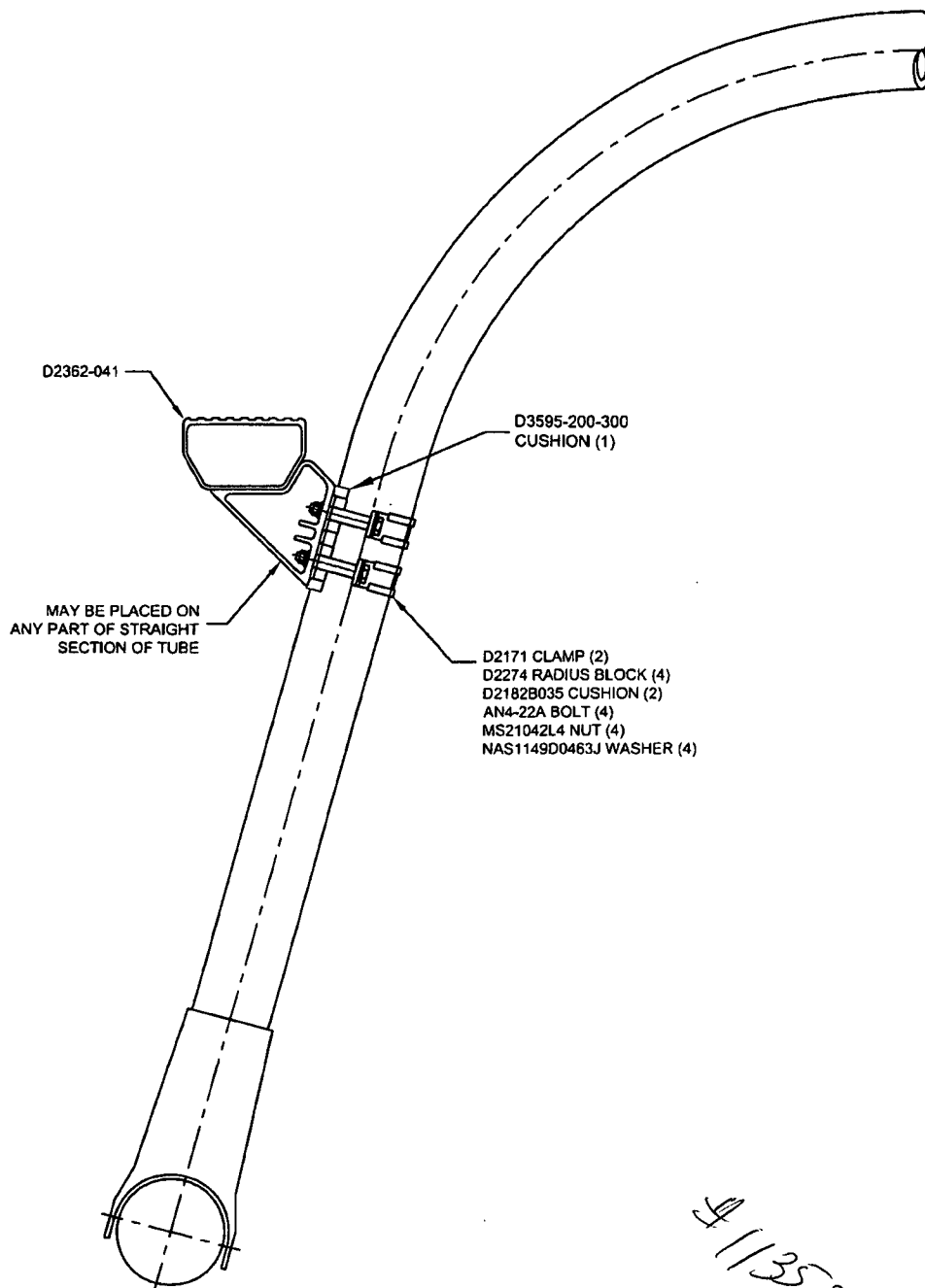


FIGURE 32-10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF ICA-D350-591

FIGURE 10: D350-591-117A Heli-Access-Step™, Pre-Flight Step
REF D350-591

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DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01






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BY: *[Signature]*
D. SHEPHERD (DE # 02)

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